

Split ship July 15

Work Order ID 60166-2

June 28, 2010 11:51:52 AM



Page 1

Item ID: D4134-041

Revision ID:

Item Name: Wearplate, LH Aft

Start Date: 6/29/10

Start Qty: 2.00

Required Date: 7/15/10

Req'd Qty: 2.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

QC:

Date: 10/6/29 Tooling:

Date: SPC (Y/N):

Date:

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4134

A

100



Waterjet

FLOW WATER JET

Memo

1-Cut D4134-1F as per Dwg D4134

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

0.00

0.00

FLOW CNC Waterjet

304 .050

110



QC

Quality Control

QC2- Inspect parts off machine FA/FAIB

Memo

0.00

0.00

120



QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

Scrap
10-09-28
Sisish Chen
Deburr m.d. 10/06/29
3x

B10-6-29

B10-6-29

8 10/06/30

Pro

3

3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

WORK ORDER CHANGES

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WORK ORDER NON-CONFORMANCE (NCR)

NCR: 60166-2

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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10.10.06	100	Design changed. PARTS NO LONGER CORRECT	W 10-10-07 JSTALZ	SCRAP 9/10.10.06 NEW PARTS MADE TO REV. B	10.10.06	S 10/10/07	W 10-10-07 JSTALZ	B 10.10.07

NOTE: Date & initial all entries

Work Order ID 60166

June 28, 2010 11:51:52 AM



Page 2

Item ID: D4134-041

Accept



Setup Start



Revision ID:

Item Name: Wearplate, LH Aft

Stop



Start Date: 6/29/10 Start Qty: 2.00



Cust Item ID:

Required Date: 7/15/10 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

130



Brake NC

Form as per dwg
NC BRAKE

0.00

Memo

0.00

I- Form using DT 3179 Die as per Dwg D4134

dt 9644

SA 10/07/13

③

9/10

B. 07-13 - one only

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

P 10.07.14 ①

150



Large Fab

Large Fab

Weld per dwg A/R Hardcoat S.S. Batch: _____
Large Fab

0.00

Memo

0.00

Weld hard surface using DT _____ as per QSI 004 and Dwg D4134

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
10/07/13	130	had to open hole at .311 to match with the jig	SB	10/07/13	③	<i>[Signature]</i> 10-07-13 (S) 1412		

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June 28, 2010 11:51:53 AM



Page 3

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Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

170



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

180



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3,5.6) per QSI005 4.3

0.00

Memo

0.00

START TIME: _____
OVEN TEMPERATURE: _____
FINISH TIME: _____

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Run Start



Stop



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NOTE: Date & initial all entries

Work Order ID 60166

June 28, 2010 11:51:53 AM



Page 4

Item ID: D4134-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearplate, LH Aft

Start Date: 6/29/10 Start Qty: 2.00



Cust Item ID:

Required Date: 7/15/10 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

190

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

200

0.00



Small Fab

Memo

0.00

Small Fab

1- Bond D4134-3 gasket to inner surface of wearplate using a thin layer of 3M 1300/1300L scotch grip adhesive
Batch: _____

210

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Work Order ID 60166

June 28, 2010 11:51:54 AM



Page 5

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Required Date: 7/15/10 Req'd Qty: 2.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

220



Packaging

Packaging

Identify as per dwg & Stock Location: _____
Packaging

Memo

0.00

0.00

230



QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

UMF
10-10-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

June 28, 2010 11:51:51 AM

Page 1

Work Order ID: 60166

Parent Item: D4134-041

Parent Item Name: Wearplate, LH Aft





Start Date: 6/29/10

Required Date: 7/15/10

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 10.06.25 new issue DD ver:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4134-3 		Manufactured	No			200	Each	0.0000	1	2.000200			
Gasket M304S18GA 		Purchased	No			100	sf	132.8779	1.5825	3.165317			
304/316 .050 Sheet													

Location

Loc Qty

Loc Code

MAT20

132.8779

111743

8.86

112885

28.0179

113062

96

1810-6-29

③

113062

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 60166
Description: WEAR PLATE LH AFT		Part Number: D4134-041
Inspection Dwg: D4134-1 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.300	$\pm .010$.303				
.300	$\pm .010$.303				
.415	$\pm .010$.412				
.82	$\pm .030$.816				
2.74	$\pm .030$	2.725				
4.65	$\pm .030$	4.640				
5.055	$\pm .010$	5.053				
5.47	$\pm .030$	5.468				
.203	$\pm .005 - .001$.205				
.375	$\pm .010$.374				
5.85	$\pm .030$	5.85				
8.249	$\pm .010$	8.250				
13.170	$\pm .010$	13.170				
15.85	$\pm .030$	15.85				
18.092	$\pm .010$	18.092				
23.03	$\pm .010$	23.013				
25.85	$\pm .030$	25.85				
27.934	$\pm .010$	27.934				
28.31	$\pm .030$	28.310				
8.05	$\pm .030$	8.048				
15.73	$\pm .030$	15.73				
15.98	$\pm .030$	15.98				
.050	$\pm .010$.050				

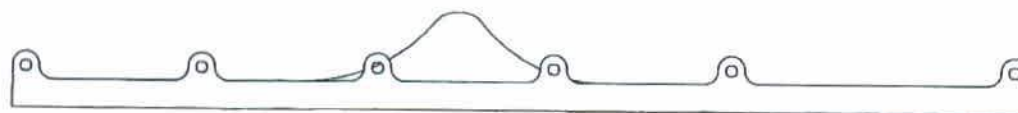
Put
AFT
this
Dim
8
w/out

Measured by: IB	Audited by: S	Prototype Approval: N/A
Date: 10-6-29	Date: 10/04/30	Date: N/A
Rev A	Date	Change
		New Issue
Revised by: KJ/JLM	Approved	

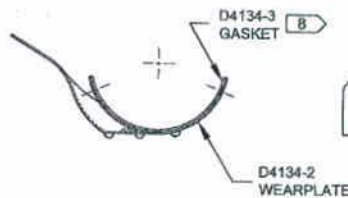
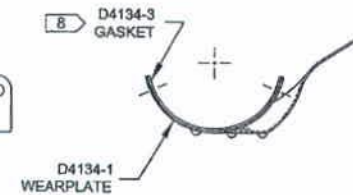
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER
NO. *60164*
PS 10629

QTY	QTY	PART NUMBER	DESCRIPTION
-041	-042		
X		D4134-041	WEARPLATE, LH AFT
	X	D4134-042	WEARPLATE, RH AFT
1		D4134-1	WEARPLATE
1	1	D4134-2	WEARPLATE
1	1	D4134-3	GASKET
A/R	A/R	13007 1300L	3M SCOTCH-GRIP ADHESIVE



D4134-041 WEARPLATE, LH AFT



D4134-042 WEARPLATE, RH AFT

RELEASED
2010-06-23
JP

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4134-xxx" USING YELLOW PAINT MARKER ON INSIDE SURFACE
- 7) WEIGHT: -041/-042 = 2.2 lbs
- 8) BOND D4134-3 GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE

REV.	NEW ISSUE	DESCRIPTION	CP	10.06.15
DESIGN	<i>99</i>	DART AEROSPACE USA, INC	BY	DATE
DRAWN	<i>99</i>	PORT HADLOCK, WA		
CHECKED	<i>99</i>	DRAWING NO.	REV. A	
MFG. APPR.	<i>99</i>	D4134	SHEET 1 OF 6	
APPROVED	<i>99</i>	TITLE	SCALE	
DE APPR.	<i>99</i>	WEARPLATE, AFT	NTS	
DATE	10.06.15	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE FURTHER CONDITION THAT IT IS NOT TO BE LOANED, REPRODUCED, COPIED, OR OTHERWISE USED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE USA, INC.		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

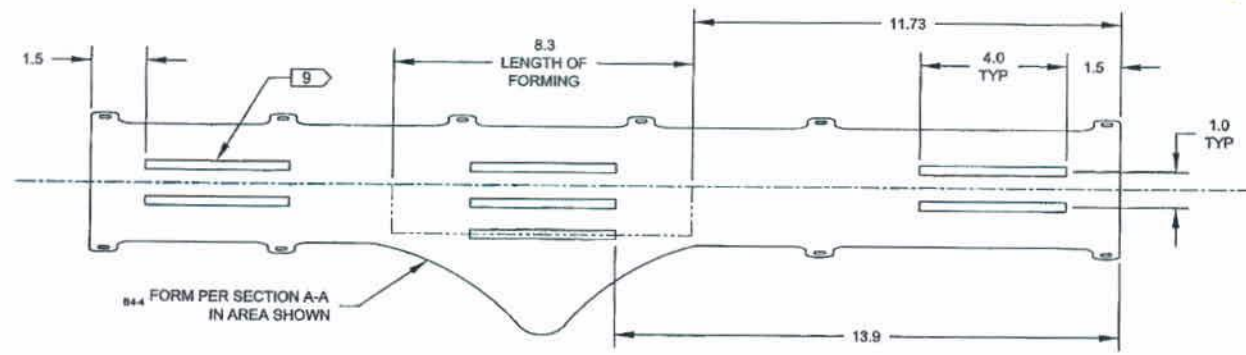
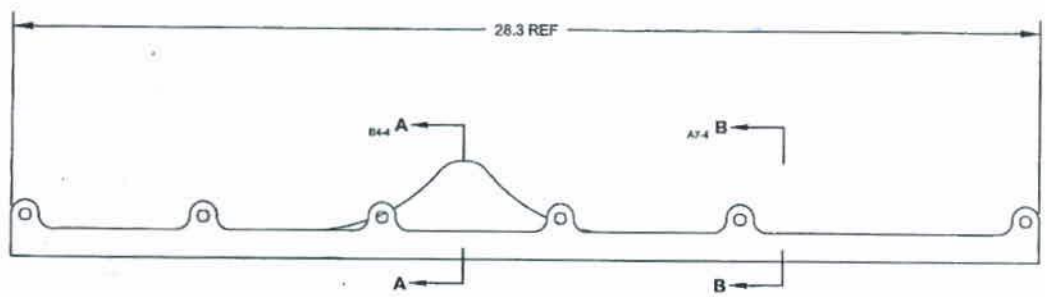
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



u/o Goldo

RELEASED
2010-06-23
JH

D4134-1 WEARPLATE, LH

- NOTES:**
- 1) MATERIAL: MAKE FROM D4134-1F
 - 2) FINISH: POWDER COAT "GREY SANDEXT" (4.3.5.6) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 1.8 lbs
 - 8) WELD PER QSI 004
 - 9) 2059B HARDCOAT WELDS, 0.063 TO 0.125 HIGH

DESIGN	92	DART AEROSPACE USA, INC	
DRAWN	92	PORT HADLOCK, WA	
CHECKED	92	DRAWING NO.	REV. A
MFG. APPR.	92	D4134	SHEET 2 OF 6
APPROVED	92	TITLE	SCALE
DE APPR.	92	WEARPLATE, AFT	NTS
DATE	10.06.15	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC	
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8 7 6 5 4 3 2 1

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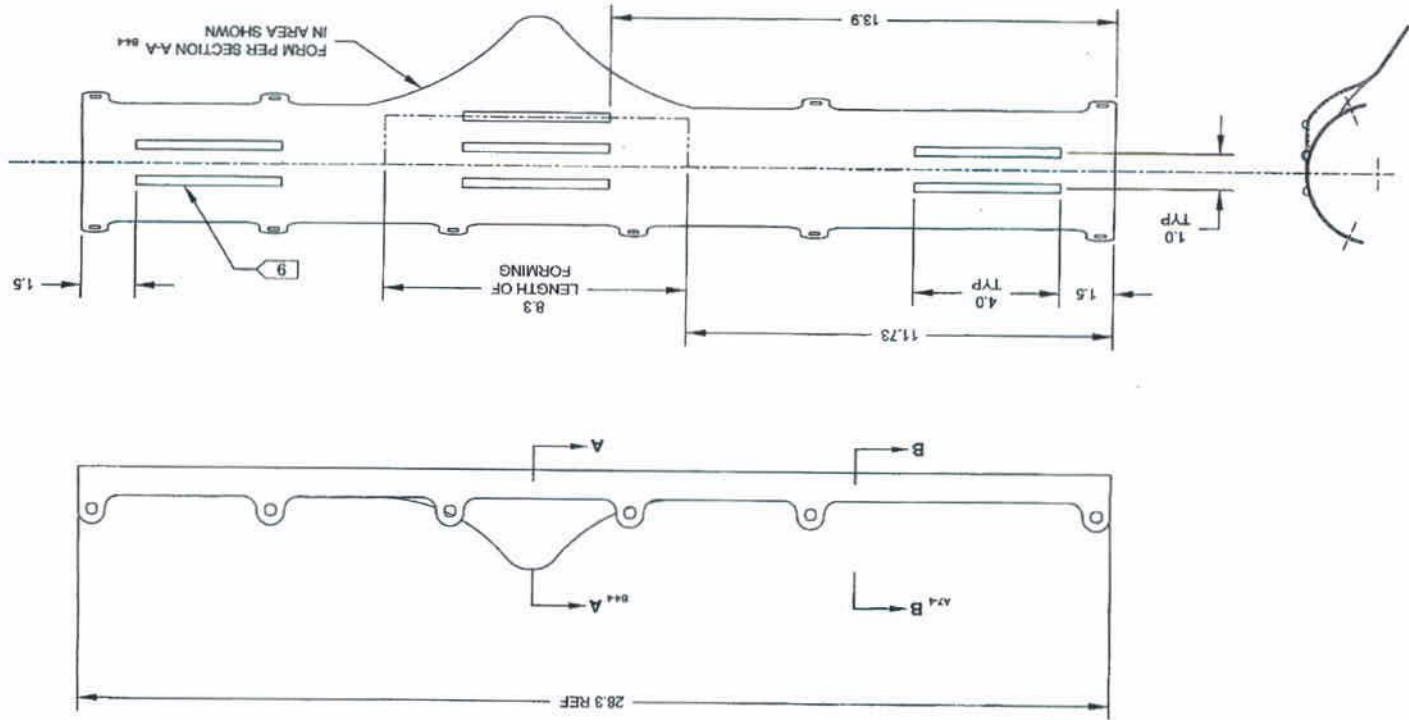
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

- NOTES:
- 1) MATERIAL: MAKE FROM D4134-1F
 - 2) FINISH: POWDER COAT "GREY SANDLEX" (4.3.6) PER DART OSI 006 4.3
 - 3) TOLERANCES: PER DART OSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.006 TO 0.010
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 1.8 lbs
 - 8) WELD PER OSI 004
 - 9) 2059B HARD COAT WELDS, 0.063 TO 0.125 HIGH

WLB
60146

D4134-2 WEARPLATE, RH



RELEASED
2010-06-23
JW

DESIGN	DATE	10.06.15
DRAWN	DE APPR.	
CHECKED	APPROVED	
DRAWING NO.	MFG. APPR.	
D4134		
SHEET 3 OF 6		
REV. A		
DART AEROSPACE USA, INC		
PORT HADLOCK, WA		
WEARPLATE, AFT		
SCALE		
HTB		

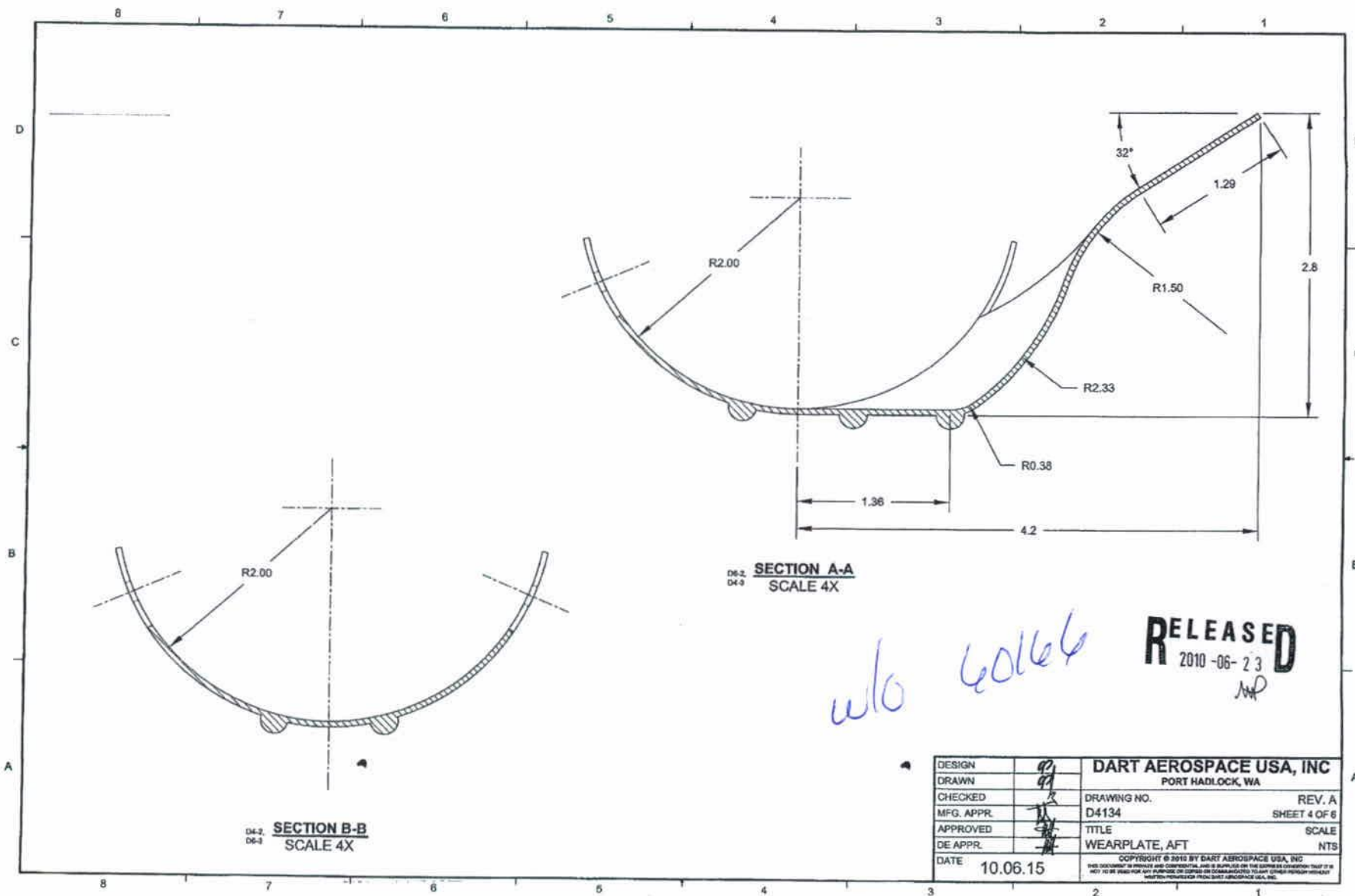
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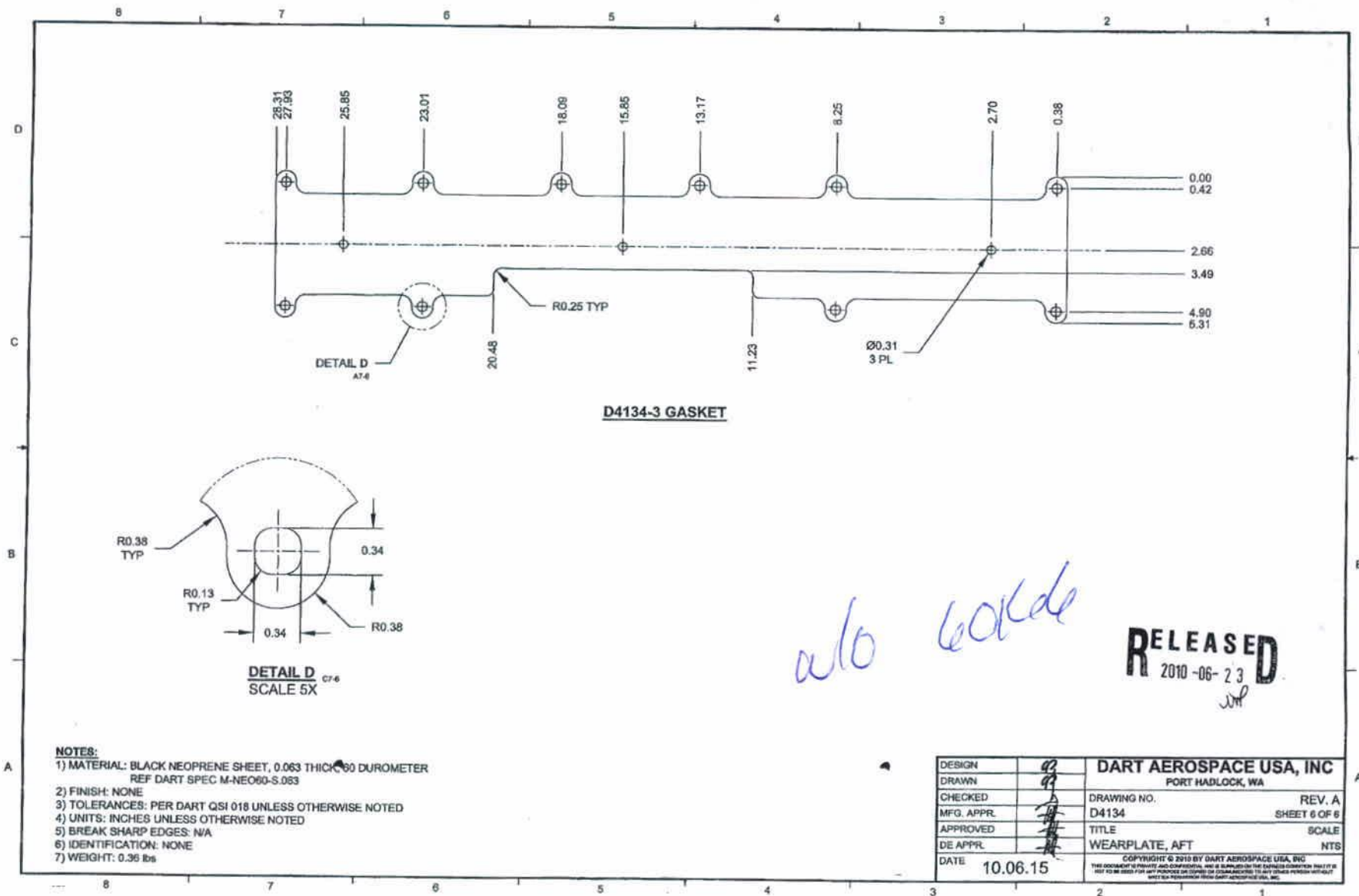
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auto looked

RELEASED
2010-06-23
JH

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